

ABSTRACT

The present invention relates to a cutting tool insert particularly for turning of steel comprising a cemented carbide body, a coating with a post treatment with

- a first, innermost layer system of one or several layers of $\text{TiC}_x\text{N}_y\text{O}_z$ with $x+y+z \leq 1$ with a total thickness of 0.7-4.5 μm
- a second multilayer system consisting of a totally 5-31 alternating Al_2O_3 and $\text{TiC}_x\text{N}_y\text{O}_z$ ($x+y+z \leq 1$), preferably $\kappa\text{-Al}_2\text{O}_3$ and TiN, the Al_2O_3 -layers having an individual layer thickness of $<0.5 \mu\text{m}$ and the $\text{TiC}_x\text{N}_y\text{O}_z$ -layers 0.01-0.2 μm with a total thickness of the multilayer of 1.0-4.0 μm . The multilayer is exposed along the edge line and into the rake and flank face, at least 0.02 mm, from the edge line on the rake face, preferably the contact length of the chip at most 0.9 mm, and 0.02-0.20 mm on the flank face.